: LATCH BRACKET

D2583 REV. B

: D2583

: N/A

:NA

: 12/08/2006

Date:

Friday, 21/07/2006 12:04:08 PM

User

Linda Lacelle

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 28018

Estimate Number

: 10994

P.O. Number

: NIA

This Issue Prsht Rev.

First Issue

: 21/07/2006

: MA

: MACHINED PARTS

: 28018

Previous Run Written By

Checked & Approved By

Comment

S.O. No. : NA

Removed P/O for Powder Coat- in house

processDM

D 06.07.21 Est:

Waterjet EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: 5052-H32 .040 Sheet

1.0

M5052H32S040

0.1227 sf(s)/Unit Total: 12.2745 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.040" thick

(M5052H32S040)

M15982 (52) Batch: M17835 158

100 Um:

Each

2.0

WATER JET

Comment: Qty.:



Lodos/18 (10) - MF. 06/08/30 (10)

Comment: FLOW WATER JET 1-Cut as per Dwg D2583

Dwg Rev: _13 Prog Rev: 3

2-Deburr if necessary -

11 D

3.0

QC2

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK

110

Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE

Comment: NC BRAKE

Deburr

Form on CNC Brake as per Dwg D2583



Page 1

Form: rprocess

Date: Friday, 21/07/2006 12:04:09 PM User: Linda Lacelle **Process Sheet** Customer: CU-DAR001 Dart Helicopters Services **Drawing Name: LATCH BRACKET** Job Number: 28018 Part Number: D2583 Job Number: Seq. #: Description: **Machine Or Operation:** HAND FINISHING1 HAND FINISHING RESOURCE #1 6.0 Comment: HAND FINISHING RESOURCE #1 SAD Acid etch and Alodine as per QSI 005 4.1 110 POWDER COATING 7.0 POWDER COATING **Comment: POWDER COATING** 06 Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION POWDER COAT/CHEMICAL CONVERSION PACKAGING 1 PACKAGING RESOURCE #4 9.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 DC DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



yo

Qty:

Date:

Friday, 7/21/2006 7:37:24 AM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

Estimate Number

: 28018 : 10994

P.O. Number

: 7/21/2006 This Issue

: NC

: // : 25326

S.O. No. :

Type

: MACHINED PARTS

Part Number

Drawing Name

: D2583

Drawing Number

: D2583 REV. B

: LATCH BRACKET

Project Number

: N/A

Drawing Revision

: B

Material **Due Date**

: 8/12/2006

100 Um:

Each

Written By

Prsht Rev.

First Issue

Previous Run

Checked & Approved By Comment

: Est:

Removed P/O for Powder Coat- in house

processDM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0 M5052H32S040

5052-H32 .040 Sheet



Comment: Qty.:

0.1227 sf(s)/Unit Total:

12.2745 sf(s)

Material: 5052-H32 (QQ-A-250/8) 0.040" thick Batch:

(M5052H32S040)

SHEAR



Comment: SHEAR

Cut blank: 4.000" x 2.130" Grain offset 10° along 3.188"

3.0

2.0

HAAS1

SHEAR

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2583

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0

BRAKE NO

NC BRAKE



Comment: NC BRAKE

Deburr

Form on CNC Brake as per Dwg D2583

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector			
06-06-28	5.0	ADD QCS to inspect bending. Perm. Change	E	06.68.20		Dagen				
	5-1	QC 5 Inspect work.	1	ch.08.28	110	1	66.08.28			
						4				

NCR:			WORK ORDE	ER NON-CONFORMAN	NCE (NCR)			
		Description of NC		Corrective Action Section I	3	Verification	Approval	Approval
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Approval Design Mgr	Approval QC Inspector
							,	·
					4			
							- 1	
				-	*		,	
							- 1	
							111	

Part No:	PAR #:	Fault Category:	NCR:	Yes Nb	DQA:	Date: <u>36/5/11</u>
NOTE: Date & initial all entries				QA: N/C C	losed:	Date:

Date: Friday, 7/21/2006 7:37:24 AM User: Kim Johnston **Process Sheet** Drawing Name: LATCH BRACKET Customer: CU-DAR001 Dart Helicopters Services Job Number: 28018 Part Number: D2583 Job Number: Seg. #: **Machine Or Operation:** Description: HAND FINISHING RESOURCE #1 6.0 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 POWDER COATING 7.0 Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 INSPECT POWDER COAT/CHEMICAL CONVERSION 8.0 QC3 Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION PACKAGING 1 PACKAGING RESOURCE #1 9.0 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 10.0 DC DOCUMENT CONTROL Comment: DOCUMENT CONTROL Inspection Level 21 X 26.01.0 Job Completion

Dart Aerospace Ltd

W/O:		WORK ORDER CHAI	NGES			· ·	
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
						4	
						,	
			<i>i</i> -				*
NCR:		WORK ORDER NON-CONFOR	MANCE (NC	K)			

NCR:		W	WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval	Annessal			
DATE	STEP	Section A	Initial Design Mgr	Action Description Design Mgr	Sign & Date	Section C	Design Mgr	Approval QC Inspector			
							,				
				·							
						!	,				
							E				
		60									

Part No:	PAR #:	Fault Category:	NCR:	Yes	No	DQA:	Date:	
NOTE: Date & initial all entries				QA: I	N/C C	losed:	Date:	

DART AEROSPACE LTD	Work Order:	28018
Description: Latch Bracket	Part Number:	D2583
Inspection Dwg: D2583 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article	Prototype
-----------------	-----------

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.188	+/-0.010	3,188			Vern	
3.380	+/-0.010	3380			Vern	
0.907	+/-0.010	0.907			Vern Vern Vern	
1.725	+/-0.010	1.725			Vern	
R0.125	+/-0.010	RO.125			Vern	
0.980	+/-0.010	0.980			Vern	
	199					
						4
			-			
					1	
				· · · · · · · · · · · · · · · · · · ·		

Measured by: 5°AD	Audited by:	Prototype Approval:	N/A
Date: 06:08:14	Date: 06.08.20	Date:	N/A

Rev	Date	Change	Revised by	Approyed
Α	04.06.25	New Issue	KJ/JLM	



		274 . 44 . 1			
DESIGN MIKE M.	DRAWN BY		ROSPACE , ONTARIO, CANADA		
CHECKED	APPROVED LE	DRAWING NO. D2583		SHEET	REV. E
DATE	*·····································	TITLE		······································	SCALE
 99.02.22		LATCH BRACKET			2:3
1					

96.07.10 NEW ISSUE В CHANGE OF 99.02.22 **FINISH** (PER TSR A887)

RELEASED KE 41.02,25

R0.125 (TYP 2 PLACES)

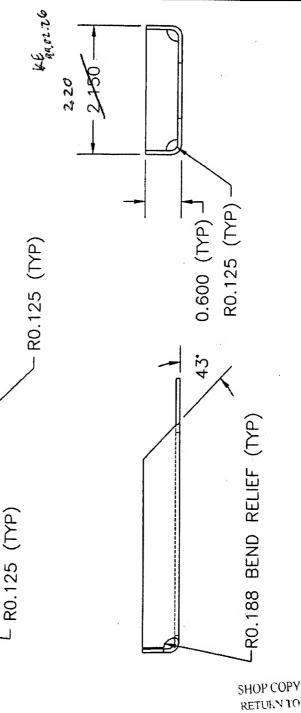
0.907

4.571

3.380

F 0.373 1.725

0.980



QSI 005 4.1 PER DART QSI 005 4.3 MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK FINISH: ACID ETCH AND ALODINE PER DART QSI POWDER COAT WHITE (REF. 4.3.5.1) PER TOLERANCES ARE

PER DART

OTHERWISE NOTED

Copyright 1996 by DART AEROSPACE LTD